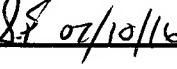
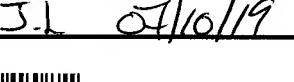
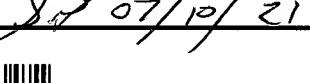


Date: Thursday, 6/7/2007 3:30:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RADIUS BLOCK
Job Number : 32857
Estimate Number : 10822
P.O. Number : N/A Part Number : D2274
This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : D2274 REV F
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : F
Previous Run : 32015 Material : N/A
Written By : J.A. Due Date : 6/30/2007 Qty: 500 Um: Each
Checked & Approved By : 6/07.06.08
Comment : Est. H 00.05.18 Added inspection level 8 EC

Additional Product

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125" 
		
	Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125"	
	Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch <u>4105061</u>	
2.0	SHEAR	SHEAR 
		
	Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK 
		
	Comment: SECOND CHECK	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: P Date: 01/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 32857

Part Number: D2274

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



723X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m/f

07/10/23

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/23

723X S9

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/10/23

723X 30

723

10.0 QC21

FINAL INSPECTION/W/O RELEASE



723
D07/10/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32851
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>J.L.</u>	Audited by: <u>J.F.</u>	Prototype Approval:
Date: <u>07/10/18</u>	Date: <u>07/10/18</u>	Date:

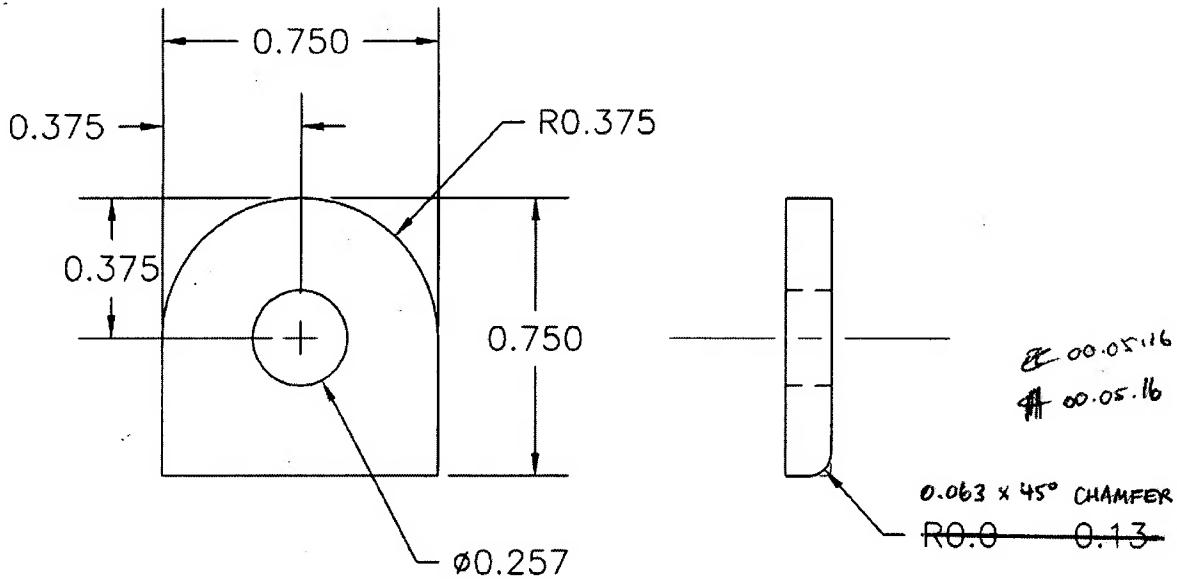
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	



1 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO. D2274
98/08/11	98/08/11	REV. F SHEET 1 OF 1
DATE	TITLE	SCALE
98.08.11	RADIUS BLOCK	2:1
A	94.09.29	NEW ISSUE
C	95.07.12	RADIUS ENDS
D	97.03.24	ADD MATERIAL SPECIFICATION
E	97.12.12	ADD FINISH & TOLERANCE QSI
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125

RELEASED
98/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 32851

